

Work Order ID 67799

Wednesday, March 30, 2011 12:57:15 PM

Page 1

Item ID: D3144-13

Accept

Setup Start

Revision ID:

Stop

Item Name: Doubler

Start Date: 3/30/2011 Start Qty: 4.00

Cust Item ID:

Required Date: 4/8/2011 Req'd Qty: 4.00

Customer:

Reference:

Approvals: Process Plan: MF Date: 11-03-30 Tooling:

Run Start

QC: Date: SPC (Y/N):

Date:

Stop

Sequence ID/ Work Center ID	Operation Description	Set Up/ Run Hours	Tool ID	Tool #	Plan Code	Accept Qty	Reject Qty	Reject Number	Insp. Stamp
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Draw Nbr	Revision Nbr
D3144	Rev C

100 0.00



Waterjet
FLOW CNC Waterjet
2024.020

PURCHASING

Memo

1-Cut as per Dwg
Dwg Rev: 2
Prog Rev: C

2-Deburr if necessary

Deburr \Rightarrow M-11/04/04

B11-4-1

(4)

110 0.00



QC
Quality Control

QC2- Inspect parts off machine FAI/FAIB

Memo

B11-4-1

W/O:		WORK ORDER CHANGES					
DATE	STEP	PROCEDURE CHANGE	By	Date	Qty	Approval Chief Eng / Prod Mgr	Approval QC Inspector

Part No: _____ PAR #: _____ Fault Category: _____ NCR: Yes No DQA: _____ Date: _____

Resolution: _____ Disposition: _____ QA: N/C Closed: _____ Date: _____

NCR:		WORK ORDER NON-CONFORMANCE (NCR)						
DATE	STEP	Description of NC Section A	Corrective Action Section B			Verification Section C	Approval Chief Eng	Approval QC Inspector
			Initial Chief Eng	Action Description Chief Eng	Sign & Date			

NOTE: Date & initial all entries

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Customer:

Reference:

Run Start



Approvals:

Process Plan:

Date:

Tooling:

Date:

QC:

Date:

SPC (Y/N):

Date:

Stop



Sequence ID/
Work Center ID

Operation
Description

Set Up/
Run Hours

Tool ID

Tool #

Plan
Code

Accept
Qty

Reject
Qty

Reject
Number

Insp.
Stamp

120

QC8- Inspect parts - second check

0.00



QC

Memo

0.00

Quality Control

140

Chemical Conversion Coat per QSI005 4.1

0.00



HandFinish

Memo

0.00

Hand Finishing

150

Black Sandtex(Ref:4.3.5.7) per QSI005 4.3

0.00



Powdercoat

Memo

0.00

Powder Coating

START TIME: 10:15
OVEN TEMPERATURE: 300
FINISH TIME: 10:45

44

4 6 11/100/10

H BL 11-47

W/O:		WORK ORDER CHANGES					
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Start Date: 3/30/2011 Start Qty: 4.00

Cust Item ID:

Required Date: 4/8/2011 Req'd Qty: 4.00

Customer:

Reference:

Run Start

Approvals:

Process Plan:

Date:

Tooling:

Date:

Stop

QC:

Date:

SPC (Y/N):

Date:

Sequence ID/
Work Center IDOperation
DescriptionSet Up/
Run Hours

Tool ID

Tool #

Plan
CodeAccept
QtyReject
QtyReject
NumberInsp.
Stamp

160

QC3- Inspect Part Finish

0.00



QC

Memo

0.00

Quality Control

4 0 11/04/07

170

Identify as per dwg & Stock Location: OA

0.00



Packaging

Memo

0.00

Packaging

11/4/11 (4)

180

QC21- Final Inspection - Work Order Release

0.00



QC

Memo

0.00

Quality Control

11/4/11
MF
11-04-11

W/O:		WORK ORDER CHANGES					
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Picklist Print

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Page 1

Work Order ID: 67799



Parent Item: D3144-13



Parent Item Name: Doubler

Start Date: 3/30/2011

Required Date: 4/8/2011

Start Qty: 4.00

Required Qty: 4.00

Comments: IPP A 04.11.29 New issue KJ/RF
now made in house DD ver:EC

IPP Rev:B 11.03.30

Component Item ID/ Item Name	Replacement Item ID	Mfg/ Purch	Bin Item	Primary Location	Last Location	Route Seq ID	Unit of Measure	Qty on Hand	Qty per Kit	Total Qty	Qty Issued	Date Issued	Status
M2024T3S.020		Purchased	No			100	sf	36.0000	1.974	8.311579			
												B11-4-1	

Alum. sheet .020

Location

Loc Qty

Loc Code

MAT22

36

103504

36

103504

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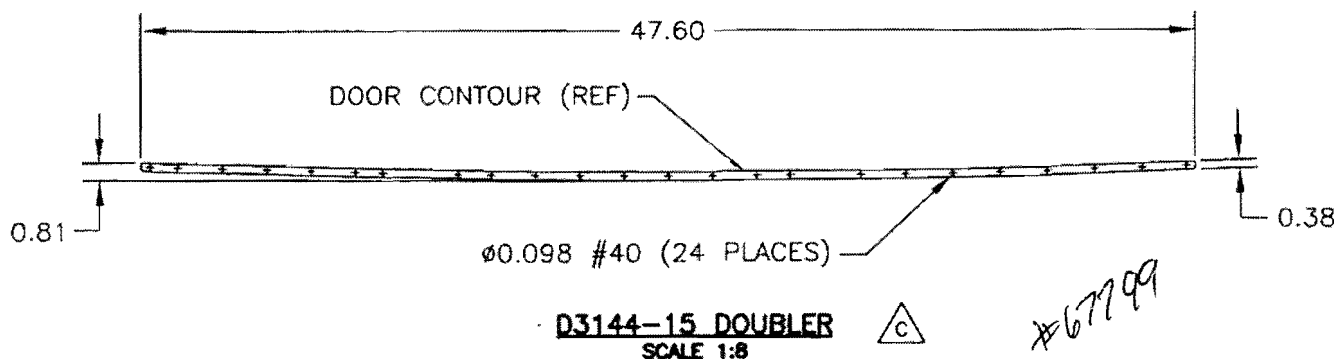
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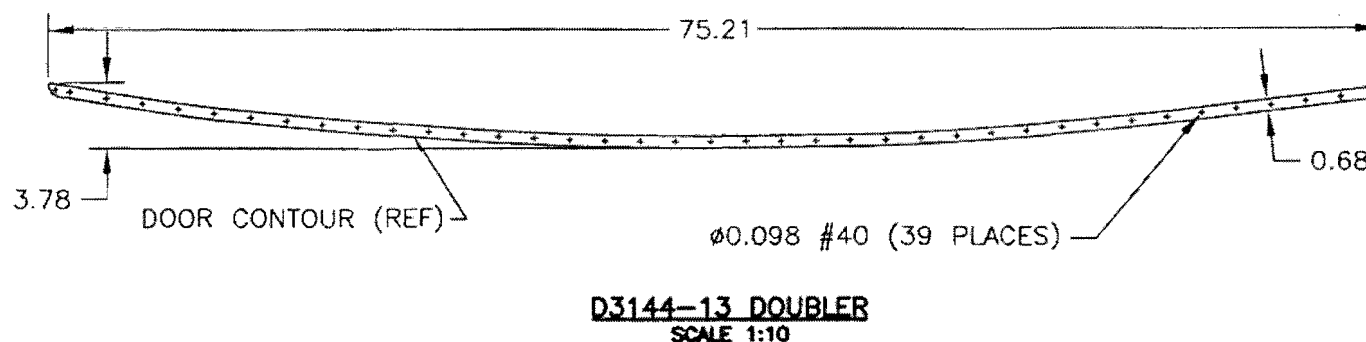
DART

RELEASED
05.11.14



D3144-15 NOTES:

- 1) MATERIAL: 2024-T3 SHEET (QQ-A-250/4) 0.032 THICK (REF DART SPEC M2024T3S.032)
- 2) FINISH: CHEMICAL CONVERSION COAT PER DART QSI 005 4.1
POWDER COAT BLACK SANDTEX (4.3.5.7) PER DART QSI 005 4.3
- 3) TOLERANCES ARE PER DART QSI 018 UNLESS OTHERWISE NOTED
- 4) ALL DIMENSIONS ARE IN INCHES
- 5) BREAK ALL SHARP EDGES 0.005 TO 0.010
- 6) MACHINE PER DRAWING FILE "D3144-C4.DWG"



D3144-13 NOTES:

- 1) MATERIAL: 2024-T3 SHEET (QQ-A-250/4) 0.020 THICK (REF DART SPEC M2024T3S.020)
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- 3) TOLERANCES ARE PER DART QSI 018 UNLESS OTHERWISE NOTED
- 4) ALL DIMENSIONS ARE IN INCHES
- 5) BREAK ALL SHARP EDGES 0.005 TO 0.010
- 6) MACHINE PER DRAWING FILE "D3144-C4.DWG"

DESIGN	RF	DRAWN BY	RF	DART AEROSPACE LTD HAWKESBURY, ONTARIO, CANADA
CHECKED	<i>[Signature]</i>	APPROVED	<i>[Signature]</i>	REV: C
DATE	05.10.19	DRAWING NO.	D3144	SHEET 4 OF 9
		TITLE	DOUBLER	SCALE NTS

W/O:		WORK ORDER CHANGES					
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